Work Order II Thursday, September 2	74444 29, 2011 2:43:22 PM									Page 1
Revision ID: Item Name: Plug Start Date: 9/29/2 Required Date: 10/14	2011 Start Qty: _8 0.0	o []]]]]		Cust Item I Customer:			Setu	up Start Stop		
Approvals: Pro	cess Plan: M.L. J	Date: 9/29/// Date:	Tooling: SPC (Y/N):		ate:		Run	Start Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool# P	lan Accode Qty		Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3492 100 Hardinge Hardinge CNC Lathe Small	Dwg Rev	s per Folio FA633 & Dwg D349	0.00	Ş 11·11	0.3	8	'o			
QC Quality Control	QC2- Inspect parts of Memo	f machine FAI/FAIB	0.00	> 11⋅	(O · 3	\$ <u>\</u>	<u>ə</u>			
120 QC Quality Control	QC8- Inspect parts - s	econd check	0.00	11/10/	3	80	ン -			

Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** STEP DATE By Qty **PROCEDURE CHANGE** Date Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR:

		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
				·				
i.								
}								

Work Order ID 74444

Thursday, September 29, 2011 2:43:22 PM



Page 2

Item ID:

D3492-1

Accept

Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Plug

Required Date: 10/14/2011

9/29/2011

Start Qty: 80.00 Req'd Qty: 80.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start

Run

Date:

SPC (Y/N):

Date:

Code

Stop



Sequence ID/

Work Center ID

Operation Description

Set Up/ **Run Hours**

Tool # Plan

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

150

HandFinish Hand Finishing

Memo

0.00

0.00

0.00

160

Powdercoat

Powder Coating

Quality Control

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Chemical Conversion Coat per QSI005 4.1

Memo

(Flat End Only) START TIME:

OVEN TEMPERATURE FINISH TIME:

OC3- Inspect Part Finish

0.00

Memo

0.00

70 Bf 11-10-6

Dart Aerospace Ltd	Da	art	Aer	OSI	oace	Ltd:
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W/O:			WC	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								·	
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
		esolution:							
NCR:			WORK ORD	ER NON-CONFORMAN	ICE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
] 									
				,					

Work Order ID 74444

Page 3

Item ID:

D3492-1

Thursday, September 29, 2011 2:43:22 PM

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Plug

Required Date: 10/14/2011

9/29/2011

Start Qty: 80.00

Req'd Qty: 80.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Set Up/

0.00

Run Hours

Date:

Stop

Sequence ID/ **Work Center ID**

180

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Memo

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

190

Quality Control

OC21- Final Inspection - Work Order Release

0.00

0.00

Dart Aerospace Ltd

W/O:			WORK ORDER C	HANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	i							
Part No) :	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date:	
	F	Resolution:	Disposition:	QA: N/C	Closed:		Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B		Verification	Approval	Approval QC Inspector				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng					
		<i>i</i> .										
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						}						
	1											

Picklist Print

Thursday, September 29, 2011 2:44:01 PM

Work Order ID: 74444

Parent Item:

D3492-1

Parent Item Name: Plug

Start Date: 9/29/2011

Required Date: 10/14/2011

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		mary Last ation Loca	Ro ion Sec		Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased	No		100	1	f	19.1800	0.0625	5.263158		•	
										De	11.	10	3/

6061-T6 Round Bar .625"

Location	Loc Oty	Loc Code
MAT012	19.18	
117284	9.09	
117481	10.09	

Page 1

Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				-					
								:	
									··
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Dispositi	on:	_ QA: N/C CI	osed:		Date: _	
NCR:		V	VORK ORE	DER NON-CONFORMA	NCE (NCF)			
DATE	OTED	Description of NC		Corrective Action Secti		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector
:									
ļ		1	1						

DART AEROSPACE LTD	Work Order:	14444
Description: Plug	Part Number:	D3492-1
Inspection Dwg: D3492 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	,059			20,02	
0.060	+/-0.005	.058	-			
Ø0.394	+/-0.010	. 394				
Ø0.625	+/-0.010	. 625		_		
0.090	+0.000/-0.002	,088				
0.500	+/-0.010	- 500				
0.050	+0.000/-0.002	.0485				
0.050 x 20°	+/-0.010	.0485	25 /		11	
		·				
•						
				,		
				-		
				_		

Measured by:	Audited by:		Preliminary Approval:	
Date: ((. 10 · 3	Date: 1	10/3	Date:	

Rev	Date	Change	Revised by Approved
A	06.06.02	New Issue P/O D3492-041	KJ/JLM
В	06.10.16	Ø0.625 was Ø0.500	KJ/JLM
С	07.11.23	Tolerances revised	KJ/EC/DD
D	08.06.19	0.050 x 20° dimension added	KJ/DD . \
Ε	11.07.26	Dimensions updated per Dwg Rev D	KJ 🖟

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANGES					
DATE	STEP	PRO	OCEDURE CHAN	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			·						
Part No	:	PAR #:	Fault Categ	ory: I	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	:	A: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section E Action Description Chief Eng	Section B Sign & Date		cation on C	Approval Chief Eng	Approval QC Inspector
						-			
ļ	1								

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

-NAS1611 O-RING (SEE TABLE) D3492-XX PLUG (SEE TABLE)

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
•			Х				D3492-047	PLUG ASSEMBLY
				Х			D3492-049	PLUG ASSEMBLY
					Х		D3492-051	PLUG ASSEMBLY
						Х	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1				*-	D3492-5	PLUG
			1		•		D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
							NAS1611-005	O-RING
	-	-	1				NAS1611-007	O-RING
1	\vdash						NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1				-		NAS1611-013	O-RING
	<u> </u>				1		NAS1611-015	O-RING
				1	-		NAS1611-016	O-RING

NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY BJECT TO AIV...
WITHOUT NOTICE
WORK ORDER
NO. 74444
M.L. J
9/29/11 SUBJECT TO AMENDMENT

RÈV.	DESCRIPTION	BY	DATE
Α	NEW ISSUE	PH	06.01.04
В	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
С	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24

DESIGN	PH	DART AEROS	PACE LTD
DRAWN	AWN A.S ECKED G. APPR. J.F.A PROVED	HAWKESBURY, ONTA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	JEA	D3492	SHEET 1 OF 2
APPROVED	VAK	TITLE	SCALE
DE APPR.	7	PLUG	2:1
DATE 11.0	05.24	COPYRIGHT © 2007 BY DAI THIS DOCUMENT IS PROVIDE AND CONFERENTIAL AND IS SUI NOT TO AS USED FOR ANY PURPOSE OR COMPEDIOR COM-	PPLED ON THE EXPRESS CONDITION THAT IT IS

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Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANGE	S				······································
DATE	STEP	PRO	CEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
N									
						·			
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	1:	QA: N/C C	losed:		Date: _	
NCR:		V	VORK ORDE	ER NON-CONFORMA	NCE (NC	₹)			
DATE	OTED	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	& Secti		Chief Eng	QC Inspector
							•		

0.060±0.005 ---ØΒ 0.090+0.000 D $c_{-0.002}^{+0.000}$ CHAMFER 0.050 X 20° **DETAIL D** POWDER COAT THESE FACES ONLY PER NOTE 2 - 0.060±0.005 0.500±0.010 (MASK PRIOR TO PAINT) D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	В	С	MATERIAL SPEC	T .
D3492-1	0.625	0.394	0.050	M6061T6R0.625	
D3492-3	0.750	0.582	0.045	M6061T6R0.750	
D3492-5	0.375	0.188	0.045	M6061T6R0.375	
D3492-7	0.500	0.270	0.045	M6061T6R0.500	
D3492-9	0.938	0.750	0.045	M6061T6R1.000	
D3492-11	0.850	0.664	0.045	M6061T6R0.875	
D3492-13	0.750	0.510	0.045	M6061T6R0.750	

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-225/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: N/A

7

DESIGN **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. D D3492 MFG. APPR. SHEET 2 OF 2 APPROVED TITLE SCALE

DE APPR. DATE 11.05.24 **PLUG** COPYRIGHT @ 2007 BY DART A EROSPACE LTD
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NOT TO BE USED FOR ANY PURPOSE OR COMPANY OR COMMAND AND TO MAY OTHER PETERS.

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Dart Aerospace Ltd

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W/O:				WORK ORDER	CHANGES	*				
DATE	STEP		PRO	CEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR	#:	Fault Category:	NCI	R: Yes	s No DQ	A:	Date: _	
	Re	esolution:		Disposition:	QA	: N/C	Closed:		Date: _	
NCR:			1	WORK ORDER NON-CON	IFORMANCE	E (NC	R)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Ammunical	Approval		
DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspecto			
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		·								
				-						